












Date: Wednesday, 10/31/2007 3:26:04 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE
Job Number	: 35471		
Estimate Number	: 11177		
P.O. Number	: N/A	Part Number	: D2281
This Issue	: 10/31/2007 S.O. No. : N/A	Drawing Number	: D2281 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: MA	Drawing Revision	: G
Previous Run	: 34181	Material	: N/A
Written By	:	Due Date	: 11/30/2007
Checked & Approved By	: 07.11.01	Qty:	100 Um: Each
Comment	: Est Rev: A Removed from 9 Digit 05-12-02 JLM		
	: Est: rev B 06.07.17 waterjet EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S14GA	304SS .080	
			
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s)			
304SS .080			
batch: 105112 RB 07-11-1			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET			
1-Cut as per Dwg D2281			
Dwg Rev: G RB 07-11-1			
Prog Rev: G			
2-Deburr if necessary RB 07-11-1			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: Deburr			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 11/1/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 35471

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 07/11/08

(98)

7.0

QC5

INSPECT WORK TO CURRENT STEP



QSP019



count

Comment: INSPECT WORK TO CURRENT STEP

07/11/08

(X98)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

WA

07-11-08

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(98)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/08

Job Completion



07-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35471
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.467				
4.114	+/-0.010	4.114				
2.933	+/-0.010	2.935				
1.535	+/-0.010	1.533				
0.354	+/-0.010	.354				
0.354	+/-0.010	.354				
0.604	+/-0.010	.604				
2.000	+/-0.010	2.000				
3.396	+/-0.010	3.396				
3.646	+/-0.010	3.646				
4.000	+/-0.010	4.000				
1.525	+/-0.010	1.525				
2.475	+/-0.010	2.479				
Ø0.323	+0.006/-0.001	.323				
0.080	+/-0.010	.077				

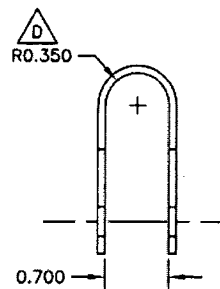
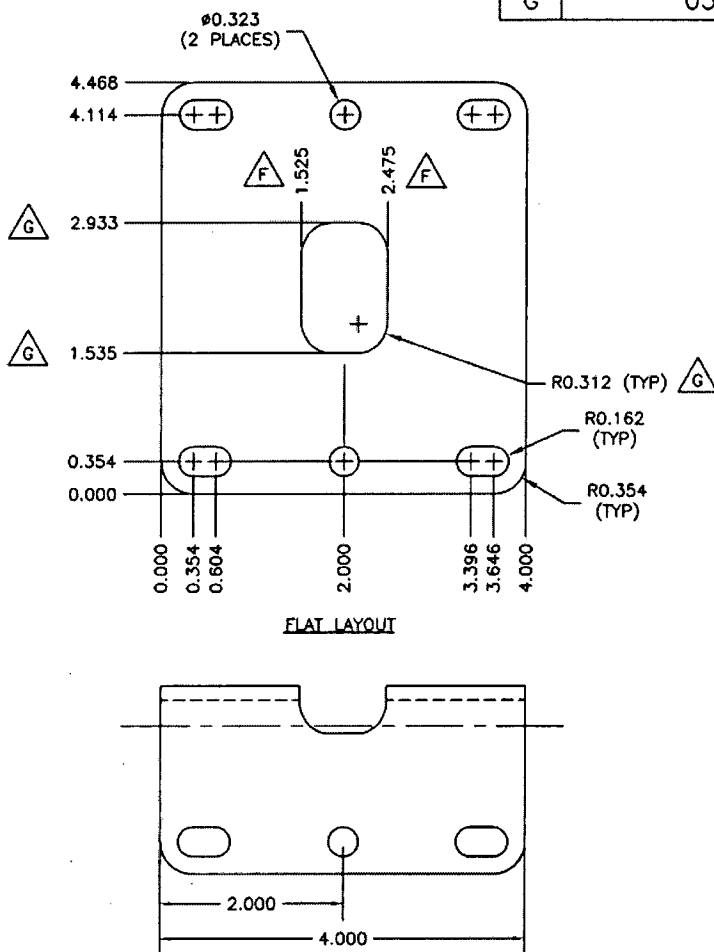
Measured by:	H3	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07-11-1	Date:	7/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35471

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